

Work Order ID 69607

Thursday, May 12, 2011 3:14:03 PM



Page 1

Item ID: D4149-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 5/12/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4149	C

100		0.00
-----	--	------



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

110	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------



QC

Memo

0.00

Quality Control

8/10/13

120	Identify as per dwg & Stock Location: 468	0.00
-----	---	------



Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69607

Thursday, May 12, 2011 3:14:04 PM



Page 2

Item ID: D4149-041	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Crosstube Lug Assembly, Aft					
Start Date: 5/12/2011	Start Qty: 4.00				
Required Date: 5/16/2011	Req'd Qty: 4.00				
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

M 6605-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Thursday, May 12, 2011 3:14:09 PM

Required Date: 5/16/2011

Required Qty: 4.00

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3 		Purchased	No			100	Each	748.0000	4	8			
Nut													
				<u>Location</u>									
				FG				80					
					103691			80					
				ST301				668					
					112314			668					
MS21043-4 		Purchased	No			100	Each	1,328.000	1	12			
Nut													
				<u>Location</u>									
				FG				40					
					104603			40					
				ST300				600					
					117423			600					
				ST301				688					
					116188			-12					
					116549			200					
					117601			500					
D3910-1 		Manufactured	No			100	Each	26.0000	1	4			
Crosstube Lug													
				<u>Location</u>									
				st507				26					
					68263			6					
					68867			20					

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 69607

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 5/12/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

D4091-1 Manufactured No

100 Each

11.0000

1



Mounting Lug

Location

Loc Qty

Loc Code

ST460

11

68868

11

D4149-1 Manufactured No

100 Each

9.0000

2



Crosstube Lug Plate, Aft

Location

Loc Qty

Loc Code

ST133

9

68869

9

D4149-3 Manufactured No

100 Each

17.0000

1



Spacer

Location

Loc Qty

Loc Code

ST133

17

68870

17

D4149-5 Manufactured No

100 Each

20.0000

1



Eyebolt Stud

Location

Loc Qty

Loc Code

ST133

20

68871

20

4
5/12/05/13

4
8
5/12/05/13

8
4
5/12/05/13

4
4
5/12/05/13

4

Thursday, May 12, 2011 3:14:10 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Thursday, May 12, 2011 3:14:10 PM

Page 3

Work Order ID: 69607

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 5/12/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

X

AN3C12A

Purchased

No

100

Each

69.0000

2

8



Bolts

Location

Loc Qty

Loc Code

ST351

69

116924

6

117313

13

117514

50



EPB 11/05/13

AN4C13A

Purchased

No

100

Each

60.0000

3

12



BOLT

Location

Loc Qty

Loc Code

ST361

60

117688

60



EPB 11/05/13

MS20615-4M18

Purchased

No

100

Each

274.0000

3

12



Rivet

Location

Loc Qty

Loc Code

ST323

274

117411

274



EPB 11/05/13

NAS1149C0332R

Purchased

No

100

Each

3,221.000

4

16



Washer

Location

Loc Qty

Loc Code

ST297

3221

116304

55

117291

2566

117460

600



EPB 11/05/13

16

Thursday, May 12, 2011 3:14:10 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, May 12, 2011 3:14:10 PM

Page 4

Work Order ID: 69607



Parent Item: D4149-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 5/12/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

100

Each

6,198.000

6

24



Washer



Handwritten signature
5/16/13

24

Location

Loc Qty

Loc Code

ST297

6198

116900

1198

117291

5000

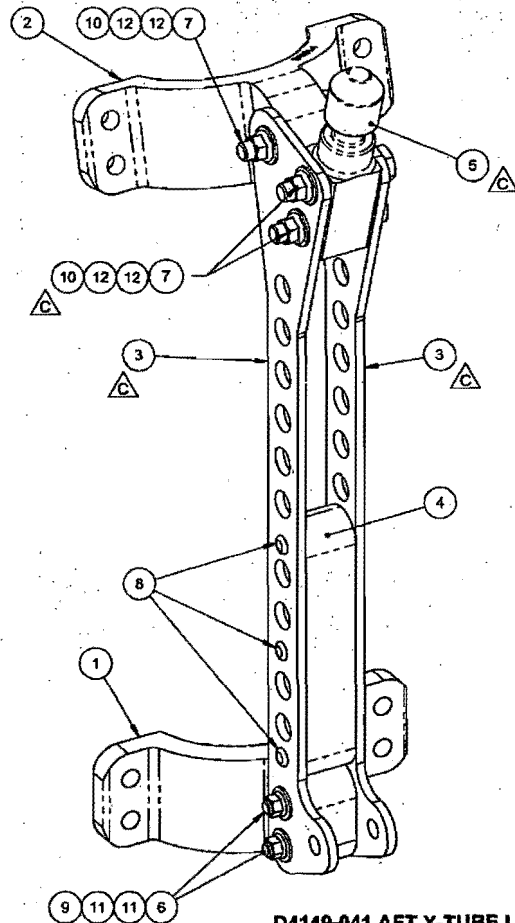
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09607

11-05-12

RELEASED
2011-02-24
JMB

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.252" (D8-3); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D360-807-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

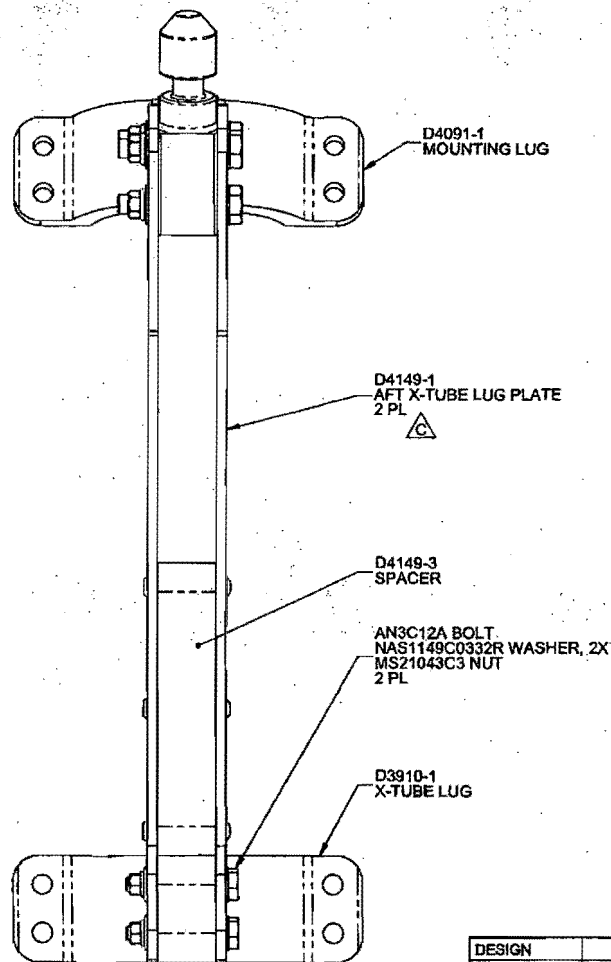
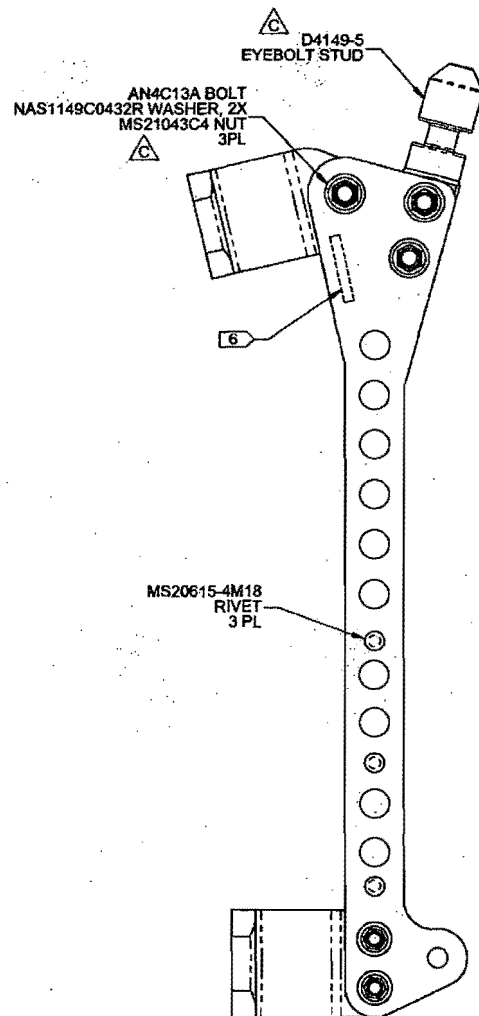
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



u/c 69607

RELEASED
2011-02-24
MP

D4149-041 AFT X-TUBE LUG ASSY

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4149	SHEET 2 OF 5
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8 7 6 5 4 3 2 1

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

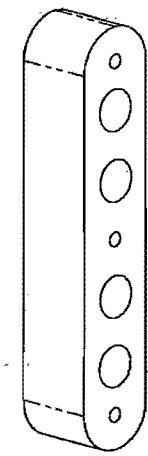
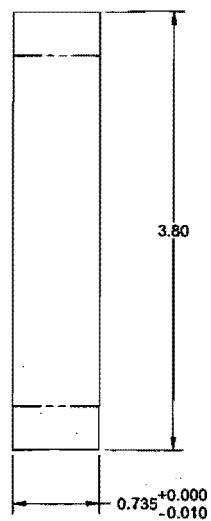
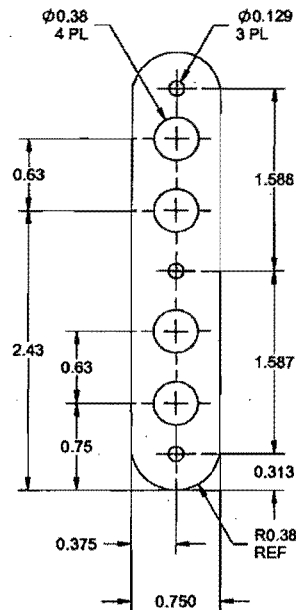
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NOTE: Date & initial all entries



D4149-3 SPACER

w/b plate

RELEASED
2011-02-24

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.47 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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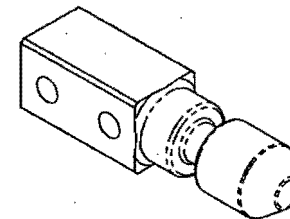
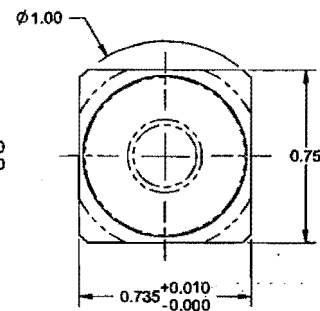
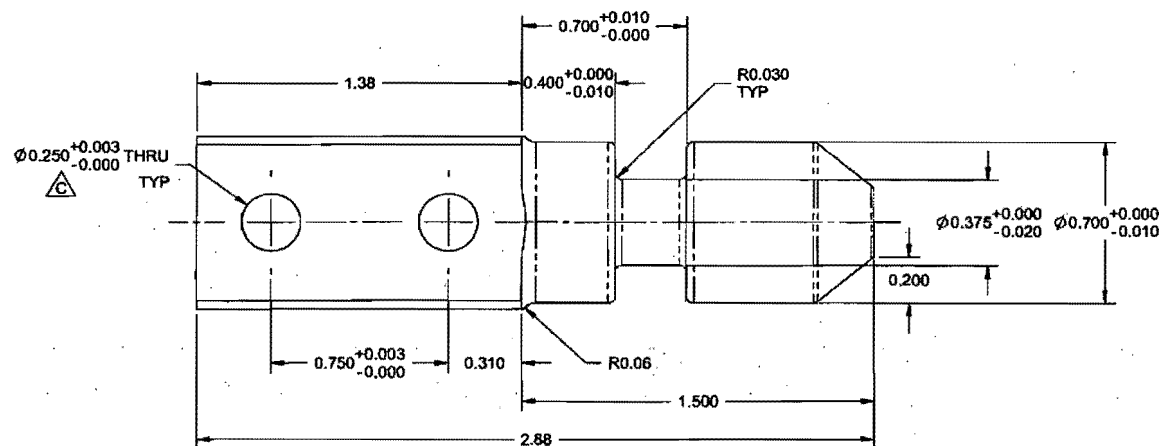
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NOTE: Date & initial all entries



D4149-5 EYEBOLT STUD

located

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 5 OF 5
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